

slp March 20

Work Order ID 79628

79628

Page 1

February-01-12 11:18:09 AM

Item ID: D206-667-107BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/02/01 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-667-147	A (DEO)
DSI9565	A
IIN-D206-667	D

100

100

DC

Document Control

DOCUMENT CONTROL

SL

0.00

Memo

0.00

Photocopy bluefile and create labels as per PPP D206-667-107 chg 002

W 12 02 23 (1)
for MJS 12-2-22

110

110

Packaging

Packaging

Pick Kit

Packaging

Memo

0.00

0.00

MD

12/2/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79628

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Item ID: D206-667-107BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Mid Fwd, Blue
 Start Date: 30/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	BENDING MACHINE - CROSSTUBES								
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D206-667-147 using CNC bender program								
130	QC15- Crosstube Dimensional Check	0.00							
130									
QC	Memo	0.00							
Quality Control									

JW MO/RM

12-2-7

8/2/02/07

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NS1

Revision ID:

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NS2

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Start Date: 30/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

Crosstubes

0.00

Crosstubes

Memo

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-147. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147.

8-C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-147 Inside of Cuff(Donot engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-147

TW

12-2-8

TW

12-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NID2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

NR2

**Insp.
Stamp**

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Start Date: 30/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Outsource process - NDT per QSI038 4.1	0.00							
180									
Outsource2	Memo	0.00							
Outsource process - NDT	CROSSTUBES								
190		0.00							
190	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

CL 12/02/10

P10:16/69

10/4/10

8/16/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Required Date: 20/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
210	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	PRIME B <u>117319</u>								
	DELFLEET BLUE B <u>118395</u>								
	CLEAR DELFLEET B <u>118093</u>								
220		0.00							
220	QC14- Inspect Spray Paint								
QC	Memo	0.00							
Quality Control	Wrap in plastic bag to protect from scratches								

AS 12-2-13

JK 12-02-14 (x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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 Required Date: 20/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe								
	2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: <u>120072</u>								
	3- Torque bolts as per dwg								
	4-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron paint.								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

AB 12-2-15

12-02-22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 79628

79628

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February-01-12 11:18:09 AM

Item ID: D206-667-107BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Mid Fwd, Blue
 Start Date: 30/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							Sp 12-02-23
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							ml 12 02 23 (1)
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							12/2/23
Packaging	Identify and pack for shipping as per PPP D206-667-107								
	Location: _____								
	PPP Rev: A								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 79628***79628***

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February-01-12 11:18:09 AM

Item ID: D206-667-107BL Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Mid Fwd, Blue
Start Date: 30/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 20/03/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/2/23
NF
12-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

February-01-12 11:18:14 AM

Page 1

Work Order ID: 79628

79628

Parent Item: D206-667-107BL

*D206-667-107BL *

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: revA 11.01.13 New Issue EC verified by:DD
11.08.08 PER ECN 11-615 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-667-147TRN

Manufactured

No

110

Each

2.0000

1

1

D206-667-147TRN

**

Crosstube Assembly, Mid Fwd

Location

Loc Qty

Loc Code

LG003

78670

2

78669

1

①

MO

12/2/6

D2873-043

Manufactured

No

230

Each

26.0000

2

2

D2873-043

**

Nut Plate Assembly

Location

Loc Qty

Loc Code

LG052

26

72644

2

73605

4

75010

20

②

D2873-045

Manufactured

No

230

Each

19.0000

2

2

D2873-045

**

Nut Plate Assembly

Location

Loc Qty

Loc Code

LG052

19

74985

19

②

D2891-1

Manufactured

No

230

Each

36.0000

2

2

D2891-1

**

2.25 Support

Location

Loc Qty

Loc Code

LG052

36

72822

16

75176

20

2

AB 12-2-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Page 2

February-01-12 11:18:14 AM

Work Order ID: 79628

79628

Parent Item: D206-667-107BL

***D206-667-107BL ***

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3595-063-395

Manufactured No

230

Each

90.0000

4

4

D3595-063-395

RUBBER CUSHION

**

AB 12-2-15

Location

Loc Qty

Loc Code

MAT052

90

70975

13

74300

77

4

cut (4)0.063" X 3.95"

MS20601-AD4W8

Purchased No

230

Each

393.0000

14

14

MS20601-AD4W8

RIVET

**

AB 12-2-13

Location

Loc Qty

Loc Code

LG

100

108521

100

LG051

115

117106

7

117381

3

117979

3

118572

2

119107

100

ST322

178

118454

78

120450

100

14

MS21920-20

Purchased No

230

Each

102.0000

4

4

MS21920-20

Clamp (per MIL-DTL-8783C)

**

AB 12-2-15

Location

Loc Qty

Loc Code

LG050

102

116799

10

119386

42

120473

50

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 79628

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Parent Item: D206-667-107BL

*D206-667-107BI *

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-30A
AN5-30A
BOLT

Purchased No

250 Each

129.0000

4 4

**

m/20717 SP

Location

Loc Qty

Loc Code

ST339

129

117514

7

118706

47

120423

75

AN5-32A
AN5-32A
Bolt

Purchased No

250 Each

274.0000

4 4

**

m/20717 SP

Location

Loc Qty

Loc Code

ST339

274

118422

2

118628

22

118983

25

119328

100

119862

50

120423

75

AN5-7A
AN5-7A
Bolt

Purchased No

250 Each

2,801.000

10 10

**

SP

Location

Loc Qty

Loc Code

ST337

2801

118422

1

119017

2800

AN960JD516 NAS1149D0563J Purchased

No

250 Each

0.0000

18 18

**

AN960JD516
Washer

m/119717 SP

12-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Crosstube Mid Fwd, Blue

79628

*D206-667-107BL *

Start Date: 30/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN970-4

Purchased

No

250

Each

148.0000

-12

12

AN970-4

Washer

**

SP

Location

Loc Qty

Loc Code

ST344

148

115936

11

116900

1

117795

61

120308

75

5x

72x

MS21042L5

Purchased

No

250

Each

1,916.000

4

4

MS21042L 5

Nut

**

SP

12-02-23

Location

Loc Qty

Loc Code

ST300

1916

116105

5

116548

43

117611

46

118179

322

119109

1500

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	AVR	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY.
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

STATIONARY

RETURN TO

STATIONARY

STATIONARY

STATIONARY

STATIONARY

STATIONARY

79628 M.L.J

12/02/01

DEO ATTACHED

ECO #11-615

11.07.28

UNDER REVIEW

RELEASED
2011-05-23

A	NEW ISSUE	CP	10.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D206-667-147
SHEET 1 OF 4

TITLE CROSSTUBE ASS'Y (206L MID FWD)
SCALE NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

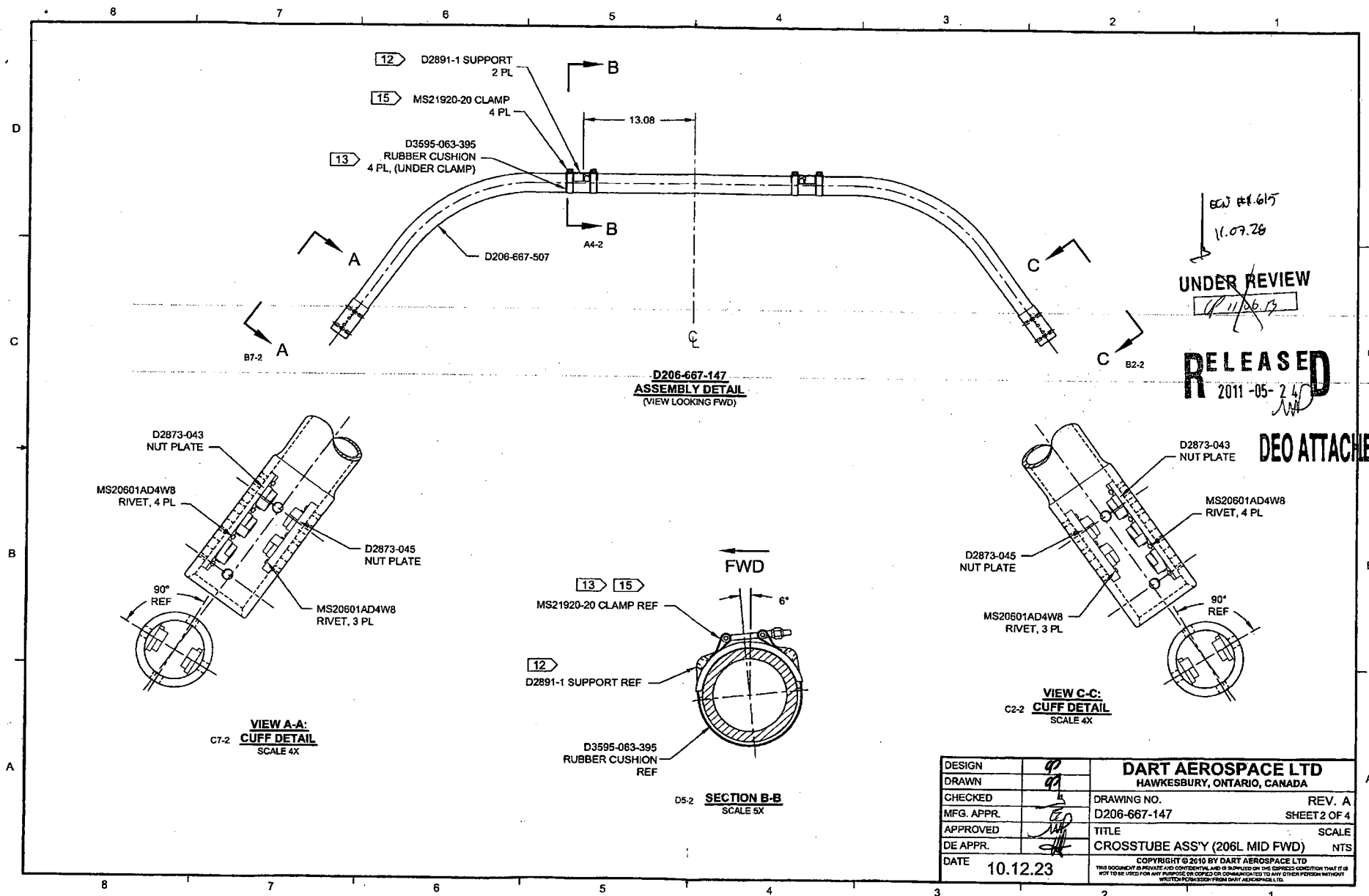
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79628



UNDER REVIEW

RELEASED
2011-05-24

DEO ATTACHED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

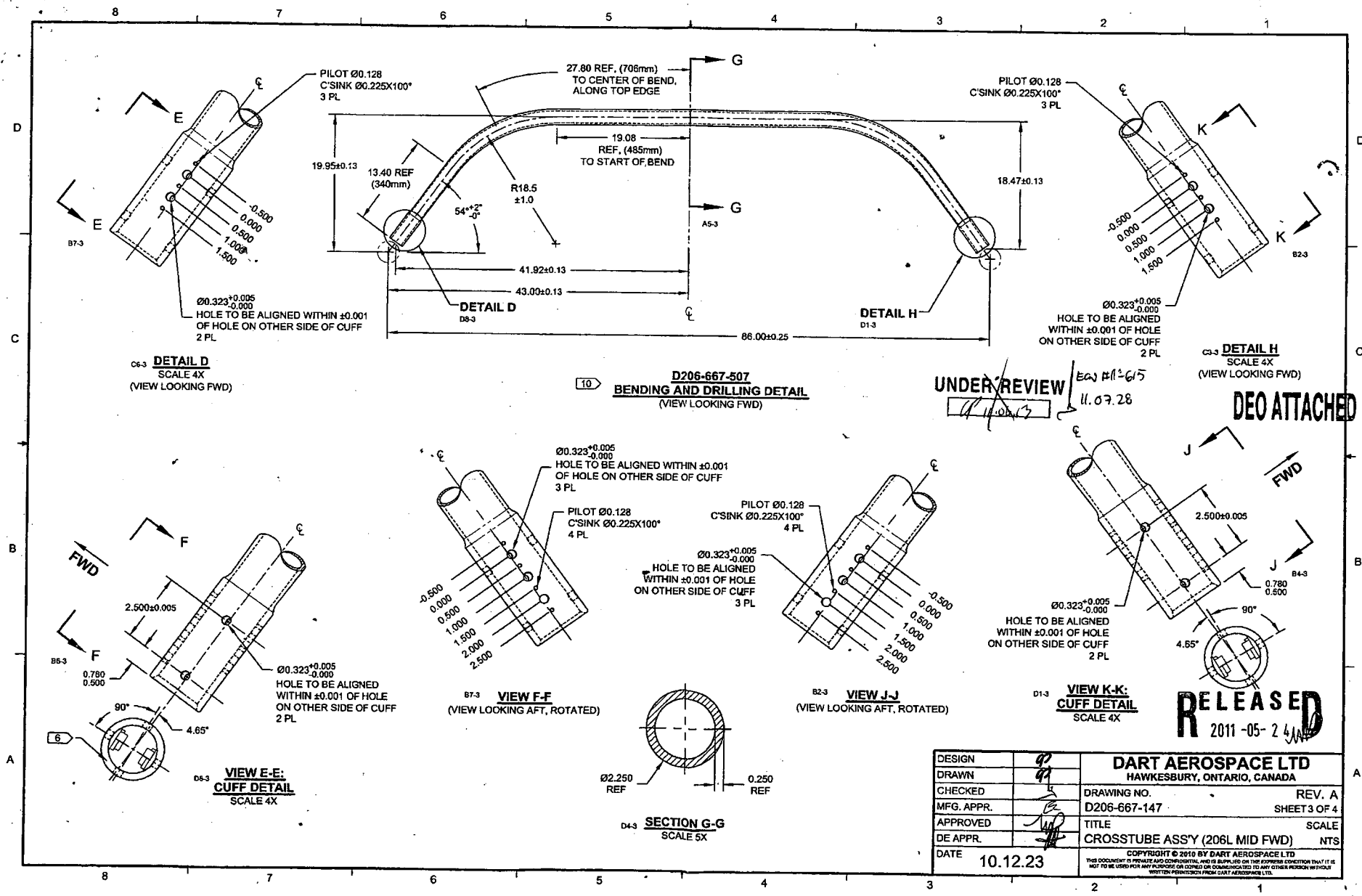
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79628



DESIGN	92	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. A
MFG. APPR.	6	D206-667-147	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	CROSSTUBE ASSY (206L MID FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

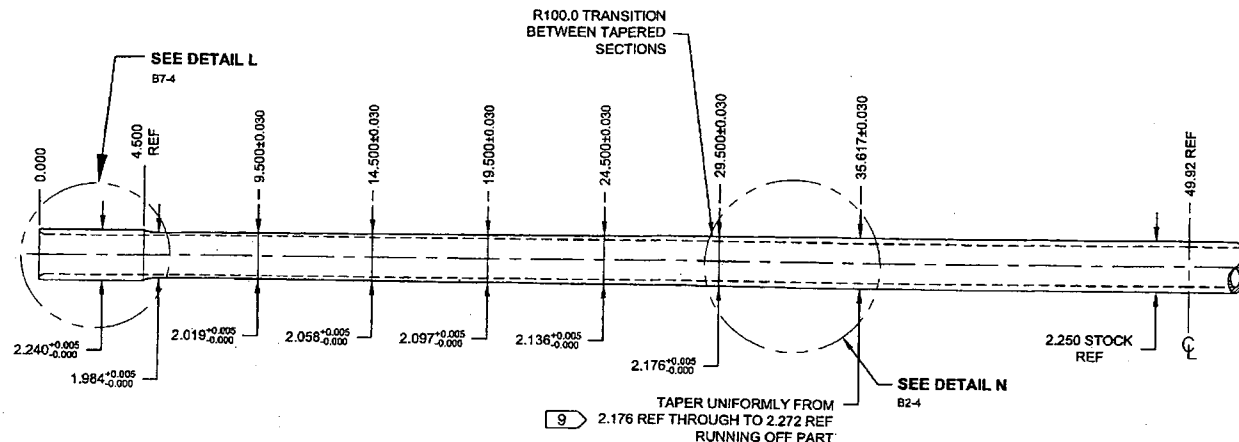
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

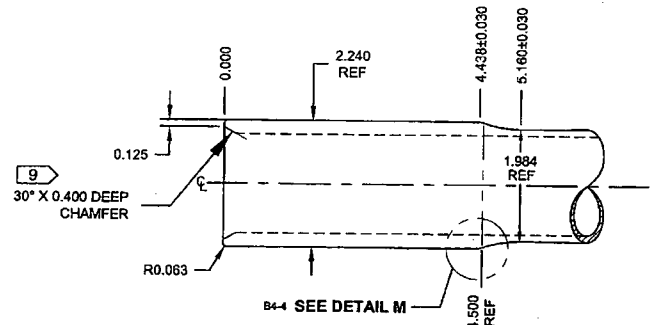
79628

UNDER REVIEW

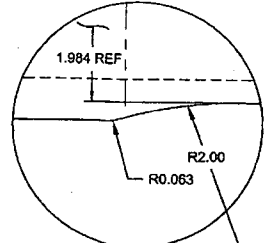
11.06.13
ECN # 11-615
11.07.28



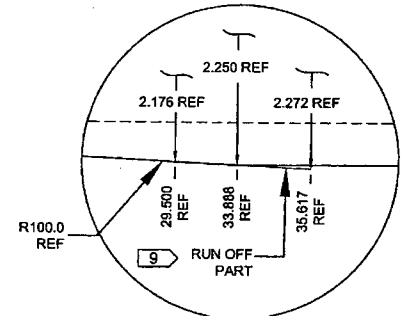
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4 NOT TO SCALE







**DETAIL M:
CUFF TRANSITION**
A6-4 NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C4-4 NOT TO SCALE

RELEASED
2011-05-23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-147	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79628

DRAWING NO. D206-667-147	TITLE CROSSTUBE ASS'Y (206L MID FWD)	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-147-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED AJS	MFG. APPR. [Signature]	APPROVED [Signature]	DE APPR. [Signature]			
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.07.21			

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -147	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTORON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	--

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79628

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D206-667 Rev. 3 OR LATER
 REF. CANADIAN STC: SH01-5
 REF. FAA STC: SR01304NY
 REF. EASA STC: EASA.IM.R.S.01179

PURPOSE:

The supports on the following crosstubes are now installed using Proseal instead of Magnobond:

D206-667-101 @ CHG 004
 D206-667-103 @ CHG 005
 D206-667-107 @ CHG 002
 D206-667-201 @ CHG 004

D206-667-203 @ CHG 004
 D206-667-207 @ CHG 002
 D407-667-105 @ CHG 004

CHANGE:

For the crosstubes listed above, section 32.4 of ICA-D206-667 is amended as follows. Use Figures 32-4 to 32-8 of ICA-D206-667 for further reference. For crosstubes of an earlier change number, it is recommended that if the supports are removed, the supports should be reinstalled using the procedure listed below.





32.4 SUPPORT INSTALLATION

- 32.4.1 Locate the area on crosstube for installation of support (ref. Figures 32-4 to 32-8 of ICA-D206-667). For D206-667-101/-103/-107/-201 and D407-667-105 crosstubes, the outward face of the support tabs should be 13.08" (332mm) from the crosstube center. For D206-667-203/-207 crosstubes, the outward face of the support tabs should be 10.03" (255mm) from the crosstube center. Ensure paint finish of crosstube is intact; touch up as required per Chapter 5 (5.3.9) of ICA-D206-667.
- 32.4.2 If present, remove any paint/primer on bottom of supports. Abrade mating surfaces of support and crosstube with 400-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.3 Ensure a layer of 3M Scotch-Weld 2216 B/A Epoxy Adhesive is on the bottom of the support. If required, either apply or touch-up support to have a 0.03" to 0.05" thick layer of adhesive over the entire mating surface. Allow supports to cure for 24 hours.
- 32.4.4 Abrade mating surfaces of support (after cure) and crosstube with 180-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.5 Apply a 0.04" to 0.07" thick layer of Proseal 890 Class B or AMS-S-8802 Class B sealant underneath applicable support and install support.
- 32.4.6 Install the clamps opposite to crosstube support as shown in Figures 32-4 to 32-8 of ICA-D206-667. Install rubber cushions underneath each clamp around the bottom circumference of the crosstube up to the crosstube centerline. Torque clamps 80-100 in-lb (9.0-11.3 Nm). It is acceptable to use smaller or larger sized MS21920-XX clamps than those listed in ICA-D206-667, ensure that after torquing the clamps per this instruction, the nuts are in safety but not bottomed out
- 32.4.7 Prior to installing crosstube on aircraft, allow supports to cure for 72 hours and recheck torque on clamps.

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: 
 D. SHEPHERD (DE # 02)

DATE: 11.07.20
 CERT. NO.: SH01-5
 ISSUE NO.: 3

A	NEW ISSUE	CP	11.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9565	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT INSTALLATION CHANGE	NTS
DATE	11.07.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

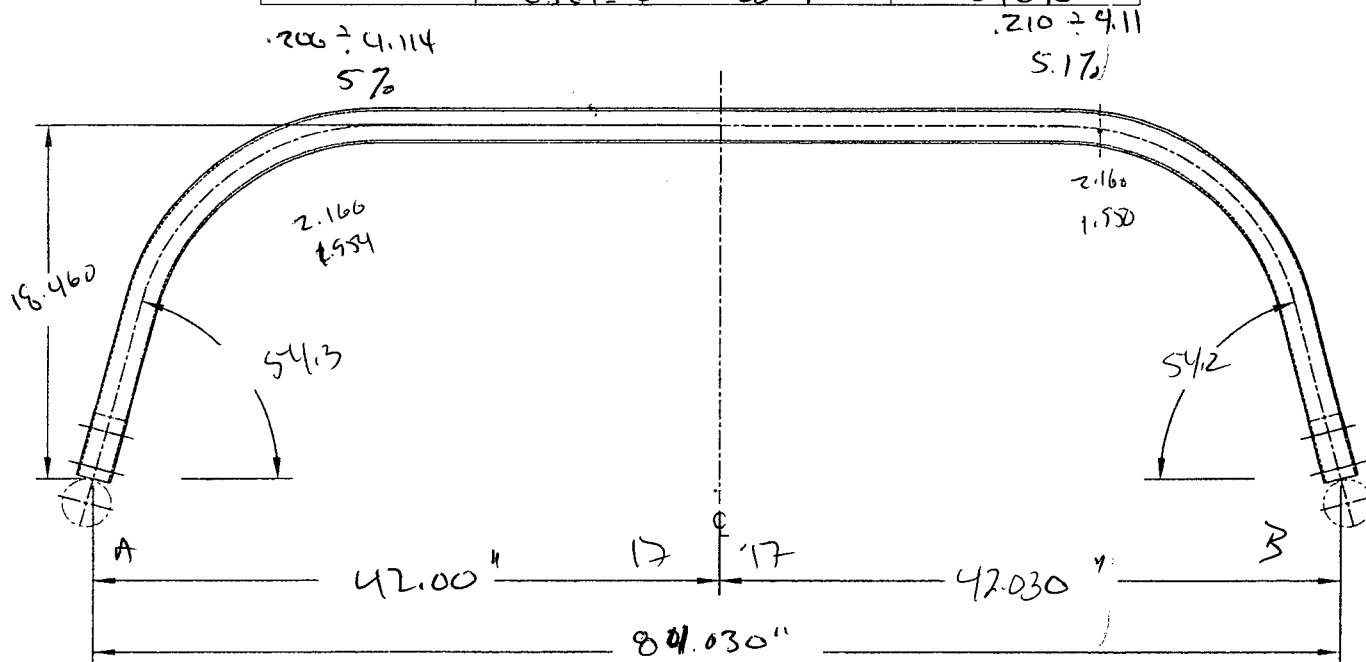
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

B79628

DART AEROSPACE LTD		Work Order:	
Description: Crosstube		Part Number:	D 206-667-407
Inspection Dwg: D 206-667-417 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height $18.47 \pm .13$	$18.340''$	$18.600''$
1/2 Span $41.92 \pm .13$	$41.79''$	$42.05''$
Angle 54 ± 3	54°	56°
Total Span $83.84 \pm .26$	$83.590''$	$84.090''$



Comments	
Side A = 5.0% crushing	17 passes
Side B = 5.1% crushing	17 passes

QC15 Inspection	8
Date	12/02/07

Rev	Date	Change	Revised by	Approved
		New Issue		

A

P

Col 113

Col 113

Col 113



LIQUID PENETRANT TEST REPORT

P-12177

CLIENT	<u>Dmt Aerospace</u>	DATE	<u>FEB 10-2012</u>	PAGE	<u>1</u> OF <u>1</u>
ATTENTION	<u>LINDA / CHANTEL</u>	ACUREN JOB NO.	<u>188-12-C0031</u>	TIME	AM <input checked="" type="checkbox"/> PM <input type="checkbox"/>
ADDRESS	<u>1270 ABERDEEN ST.</u> <u>HAWKESBURY ON.</u>	PO/VO NO.	<u>N/A</u>		
		WORK LOCATION	<u>SAME</u>		
		ACCEPTANCE STD	<u>ASTM 1417/251-038</u>	REV./DATE	<u>2005</u>
PROJECT	<u>F.P.T. on CROSS TUBES AND MACHINED PARTS</u>				
ITEM(S) EXAMINED	<u>(4) CROSS TUBES (5) MOUNTS</u>				

JOB DESCRIPTION	PROCEDURE NO.	LT <u>0002</u> REV./DATE <u>2008</u>	TECHNIQUE NO.	LT <u>1417</u> REV./DATE <u>2008</u>
PART NO.	<u>SEE RESULTS</u>		MATERIAL	<u>ALUMINE ALUMINUM</u>
SCOPE	THICKNESS <u>VARIOUS</u> <u>WET FLUORESCENT LIQUID PENETRANT INSPECTION</u> <u>CARRIED OUT ON 100% EXTERNAL SURFACE.</u>			

TEST DETAILS					
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	<u>MAGNAFLUX</u>		BLACK LIGHT S/N	<u>16459</u>	<input type="checkbox"/> OUTPUT > 1000 μ W/CM ²
PENETRANT	<u>2407</u>	MINIMUM DWELL TIME	<u>45</u>	MIN.	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANT REMOVER	<u>H2O</u>	MINIMUM DRY TIME	<u>>10</u>	MIN.	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
DEVELOPER	<u>SKD 52</u>	MINIMUM DWELL TIME	<u>10</u>	MIN.	OTHER <u>LABINO</u>
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY	LIGHT METER S/N	<u>1098866</u>
				CAL DUE DATE	<u>JULY 27 2012</u>

TEST SURFACE					
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input checked="" type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS-	<input checked="" type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL
<u>5 MOUNTS - W.O. 77271</u> ✓	
<u>1 Cross Tube W.O. 76449</u> ✓	
<u>1 Cross Tube W.O. 76449</u> ✓	
<u>1 Cross Tube W.O. 79628</u> ✓	
<u>1 Cross Tube W.O. 79627</u> ✓	
<u>8/12/10</u>	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	<u>Andrew Sheldon</u> PRINT <u>ASheldon</u> SIGNATURE
TECHNICIAN (SIGNATURE):	<u>Mike Ilnes</u> 1 st TECHNICIAN <u> </u> 2 nd TECHNICIAN
NAME (PRINT):	<u>Mike Ilnes</u> CGSB LEVEL <u>II</u> SNT LEVEL <u> </u> CGSB REG. NO. <u>6006</u>
	<u> </u> CGSB LEVEL <u> </u> SNT LEVEL <u> </u> CGSB REG. NO. <u> </u>
DTR # <u>E63807</u>	
REPORT REVIEWED BY: NAME INITIALS	

5.2 MID-HEIGHT CROSSTUBES

Item	Qty -107	Qty -207	Part Number	Description
	X		D206-667-107	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID FWD
		X	D206-667-207	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID AFT
7	1		D206-667-147	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID FWD
8		1	D206-667-247	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID AFT
10	*2		D2891-1	SUPPORT
11		*2	D2892-1	SUPPORT
13	*4		D3595-063-395	RUBBER CUSHION
14		*4	D3595-063-450	RUBBER CUSHION
16	*4		MS21920-20	CLAMP
17		*4	MS21920-22	CLAMP
19	4		AN5-32A	BOLT
20		4	AN5-34A	BOLT
21	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	NAS1149C0563J	WASHER (OR AN950JD516)
40	*2	*2	D2873-043	NUT PLATE
41	*2	*2	D2873-045	NUT PLATE
44	10		AN5-7A	BOLT
45		10	AN5-10A	BOLT
46	4		AN5-30A	BOLT
47		4	AN5-32A	BOLT
48	12		AN970-4	WASHER (OPTIONAL)
50	10	10	NAS1149C0563J	WASHER (OR AN960JD516)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-147-247 ASSEMBLIES ABOVE